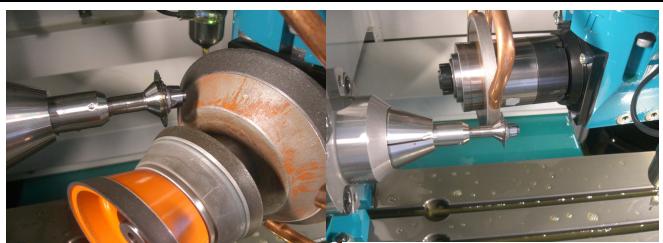


# Staggered SideMilling Cutter Ø32 Z48

A04-015

This multitooth staggered side milling cutter is ground from a solid thin disc. The flute operation interpolates the geometrically defined bottom radius. OD and Chamfer operations are executed in optimized movements , where the main grinding movement is done Z-direction. The concave sides are ground with cylindrical grinding operations.



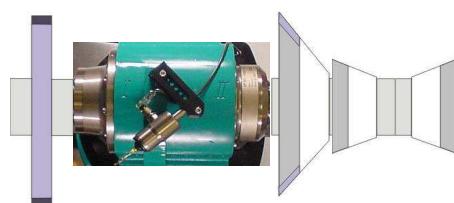
## 1. Cycletime for Production

Workpiece:	Diameter 32 mm, Z 48, Length of cutting edge 0.45 mm, Helix angle 0°						
Material HSS							
Operations	Probe	Flute 1	O.D.1	Chamf. front	Chamf. back	conc. front	conc. back
Feed [mm/Min]	2000	200	400	400	400	3000	3000
Power [kW]		4	1	1	1	1	1
Cutting feed [m/s]		32	32	32	32	32	32
Used wheels							
Grinding time [s]	8	62	55	46	46	101	101
Total cycle time	6 Min 57						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

1	12V9 Ø125 B126
2	11V9 Ø75 B106
3	11V9 Ø75 B106
4	1A1 Ø125 B91



[ 4 ]

[ 1 ] [ 3 ] [ 2 ]

## 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR  
 Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 bar  
 Software: Quinto 5

Responsible engineer: OP 22.5.09

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